

Date: Monday, 1/7/2008 3:38:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CROSSTUBE	
Job Number	: 36620		Part Number	: D2890	
Estimate Number	: 10377		Drawing Number	: D2890 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/7/2008	S.O. No.	: N/A	Drawing Revision	: B
Prsht Rev.	: NC		Type	: PURCHASED PARTS	
First Issue	: N/A		Material	: N/A	
Previous Run	: 35423		Due Date	: 1/14/2008	
Written By	:		Qty:	1 Um: Each	
Checked & Approved By	:		08.01.08		
Comment	: Est. 05.03.21 Removed Bending procedures KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part #	Description
1	D6008-180	Crosstube extrusion
		EL 8-1-9
2.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE		
1-Bend D2890 as per Dwg D2890 and Folio FT002		
		EL 8-1-10
3.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		
		108.01.11 (1)
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1		
1-Deburr and Polish		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8-1-9	2	1st tube broke on side bend programs.	08/01/15	- SCRAP & Replace. - No apparent voids were noticed in the material.	22 8-1-9	08/01/10	08/01/15	08/01/15

NOTE: Date & initial all entries

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Drawing Name: AFT CROSSTUBE

Job Number: 36620

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NIA



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



08.01.11 ①



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W.O 36470 (-107)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 8/01/15

Job Completion



u 08.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

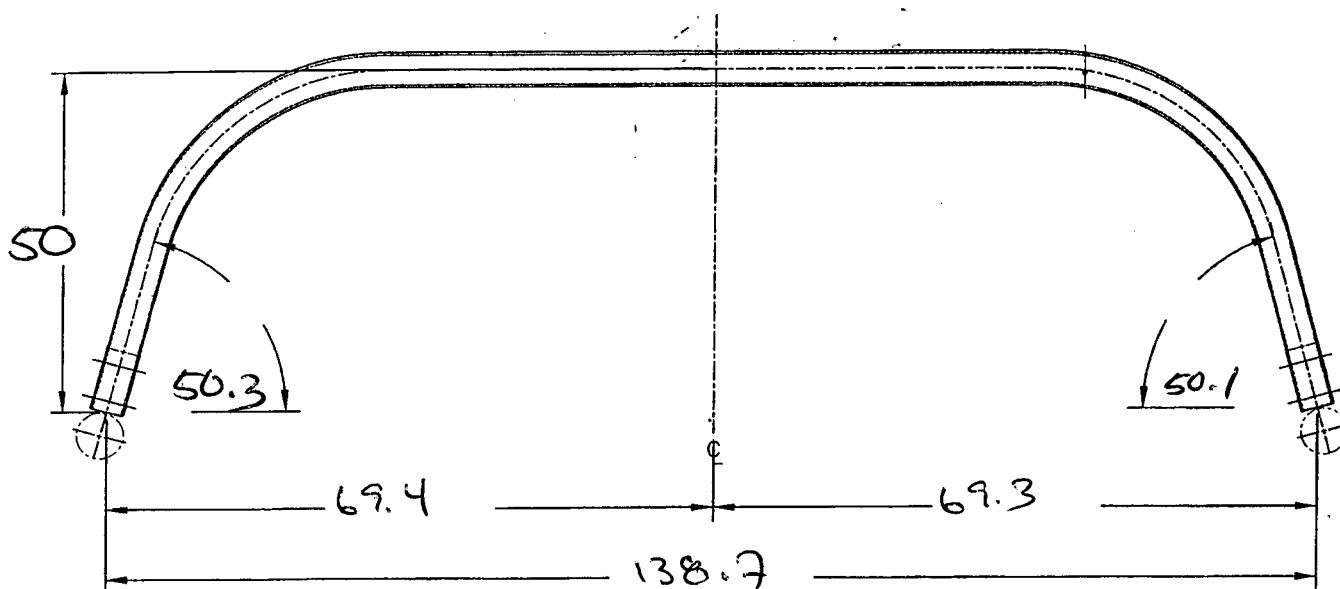
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36620
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

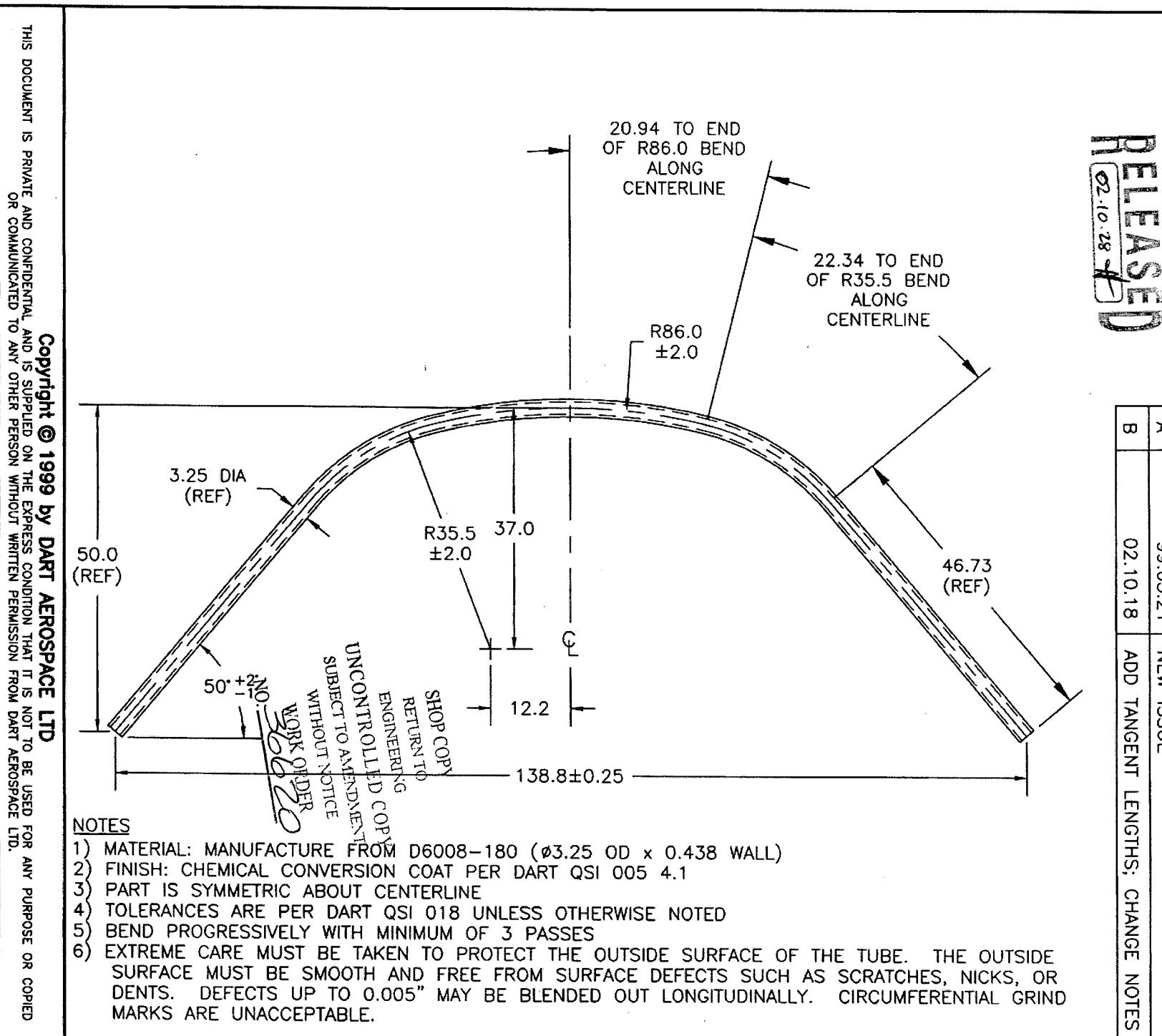
Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

QC15 Inspection	<i>[Signature]</i>
Date	08-01-11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>



DART

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DART

RELEASED
02-10-28

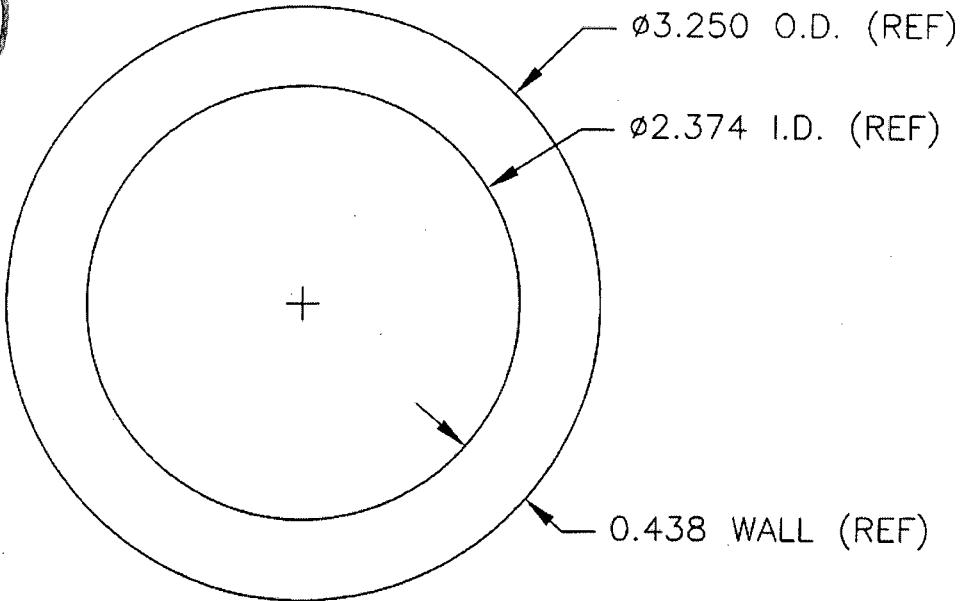
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2890	SHEET 1 OF 1
DATE		TITLE	SCALE
A	99.05.21	NEW ISSUE	1:20
B	02.10.18	AFT CROSSTUBE	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1
00.11.17		SCALE 1:1
A	00.11.17	NEW ISSUE

SPECIFICATION CONTROL DRAWING

RELEASED
(00.11.24)



NOTES

1) D6008-XXX CROSSTUBE

 LENGTH

WHERE XXX IS LENGTH IN INCHES
 EG. 180" LONG TUBE: D6008-180

2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-205/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
 MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
 MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
 O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
 WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
 LENGTH: XXX $+0.125/-0.000$
 STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 36620